

Work Order ID 82303

82303

Page 1

March-28-12 2:32:19 PM

Item ID: D3637-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 28/03/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/04/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLT Date: 12/03/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3637	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
 304 .080 Debur if necessary

10 0 Jun 12-6-25

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

10 0 Jun 12-6-25

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

10 0 Jun 12-6-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00				10			SA 12/07/05
Brake NC	Form as per Dwg D3637								
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00				10			12/07/05
Small Fab	1 - drill holes as per dwg using DT89792-C'Sink as per Dwg D3637 3 - Install Nut plate as per Dwg D3637								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

DAS
16
2-03
12/07/13

(HD)

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March-28-12 2:32:19 PM

Item ID: D3637-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket Assembly

Start Date: 28/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: **ST 235A** 0.00***160***

Packaging

Memo

0.00

100

12-7-16

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

12/7/17

mf

12-07-16

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

March-28-12 2:32:22 PM

Page 1

Work Order ID: 82303

82303

Parent Item: D3637-041

D3637-041

Parent Item Name: Bracket Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-3 Purchased No

MS20426AD3-3

Rivet

Location

Loc Qty

Loc Code

ST316

4223

119109

788

121011

3000

19099

435

M304S14GA Purchased No

M304S14GA

304SS sheet .080

140 sf 100.6000 0.09

**

0.947368

Location

Loc Qty

Loc Code

MAT020

100.6

117933

6.6

119276

94

MS21059L4 Purchased No

MS21059L4

Nutplate

140 Each 91.0000 1

**

119276

Location

Loc Qty

Loc Code

ST301

16

117887

3

119623

13

ST302

75

120930

25

121060

50

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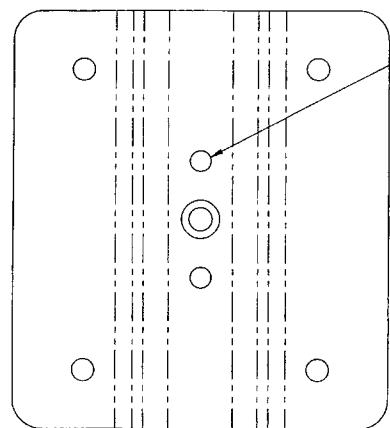
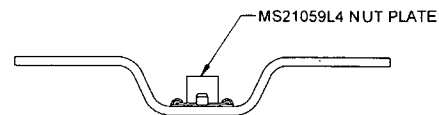
W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET

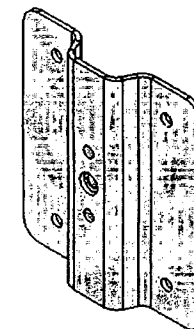
D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82303 MLJ
12/03/28

RELEASED
76-02-05

B	FOR D3637-1, 1.15 WAS 1:30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3637 TITLE BRACKET REV. B SHEET 1 OF 3 SCALE 1:1	
DRAWN	LE		
CHECKED	MA		
MFG. APPR.	LE		
APPROVED	MA		
DE APPR.	MA		
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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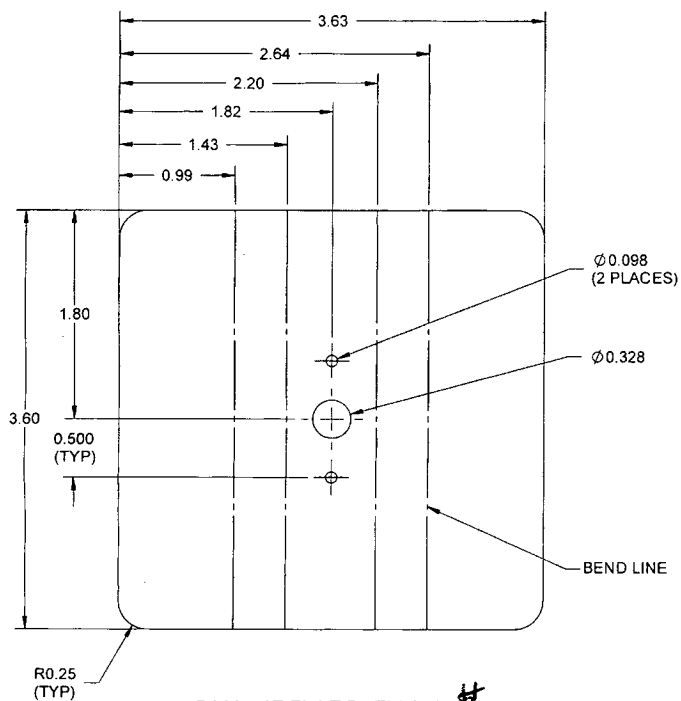
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

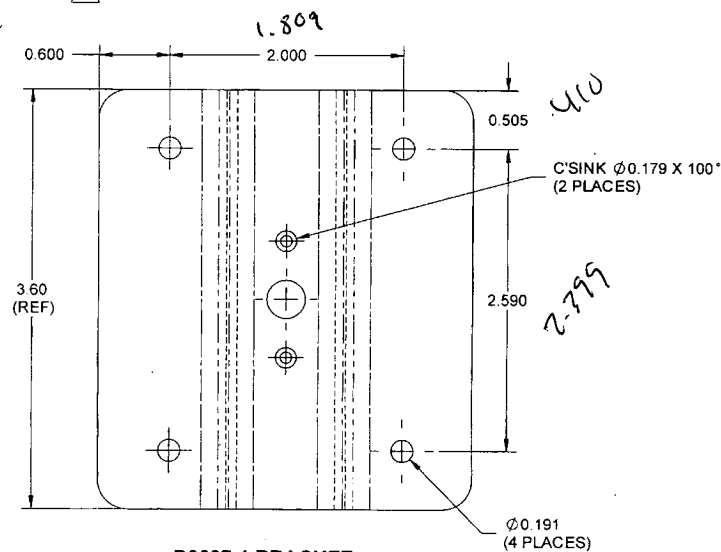
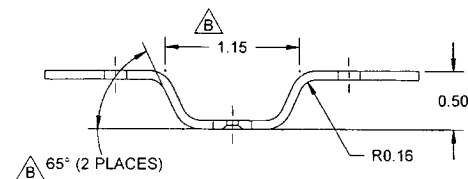
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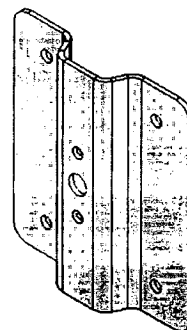
82303



D3637-1F FLAT PATTERN



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)



D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO. D3637	REV. B
MFG. APPR.	LS	SHEET 2 OF 3	
APPROVED	JS	TITLE BRACKET	SCALE
DE APPR.	JS	1:1	
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08-02-03

W/O:		WORK ORDER CHANGES					
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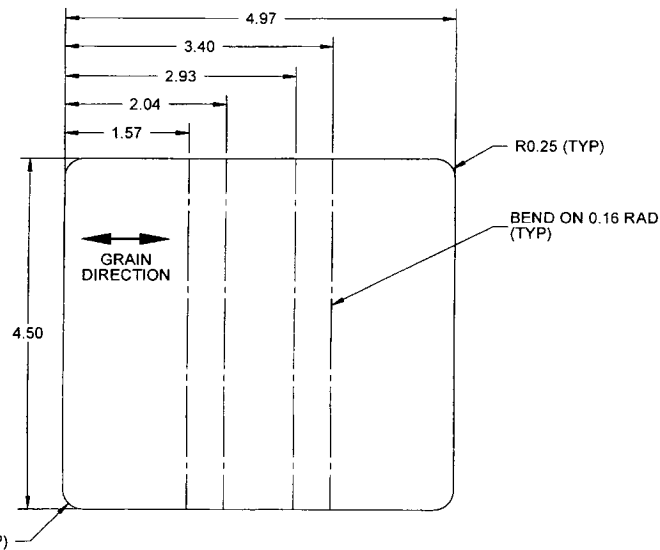
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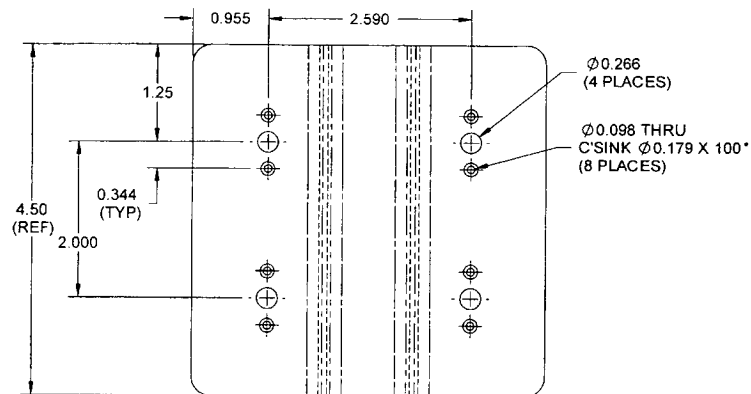
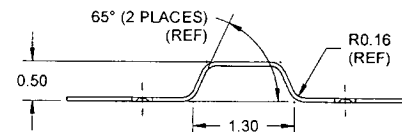
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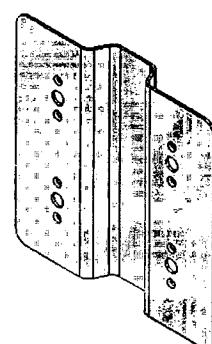
82303



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	ED	D3637	SHEET 3 OF 3
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	BRACKET	2:3
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